

Work Order ID 63551

Thursday, November 04, 2010 10:03:08 AM



Page 1

Item ID: D3219-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 11/4/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

10-11-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3219

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3219

Dwg Rev: *A*

Prog Rev: *A*

6061 .125

B10-11-8

168

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-11-8

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

cont'd

168

Solulug

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63551

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Page 2

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Required Date: 11/19/2010 Req'd Qty: 100.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-Deburr if necessary.

10-11-8

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

Memo

0.00

*** STOCK IN STEP CELL***

10.11.15

168

W/O:		WORK ORDER CHANGES					
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Page 3

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Setup Start

Revision ID:

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Item Name: Plate

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/10 [Signature]
pt 10-11-15

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NOTE: Date & initial all entries

Picklist Print

Thursday, November 04, 2010 10:03:13 AM

Page 1

Work Order ID: 63551

Parent Item: D3219-1

Parent Item Name: Plate



Start Date: 11/4/2010

Required Date: 11/19/2010

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP A 04.04.19 New issue KJ/JLM
ESR B 06.05.25 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 		Purchased	No			100	sf	88.2600	0.0964	10.14737	16.5		
6061-T6 .125 Sheet											1810-11-8		

Location

Loc Qty

Loc Code

MAT21

88.26

113608

88.26

113608

168

W/O:		WORK ORDER CHANGES					
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DART AFROSPACE LTD		Work Order:	43551
Description: Plate		Part Number:	D3219-1
Inspection Dwg: D3219	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.313	+0.005/-0.000	.320	*		V H302	
2.293	+/-0.005	2.291	*		V	
2.965	+/-0.010	2.964	*		V	
0.566	+/-0.010	.566	*		V	
0.375	+/-0.010	.375	*		V	
R0.125	+/-0.010	.125	*		R.G.	
13.9°	+/-0.5°	13.9°	*		V	

Measured by: R	Audited by: S	Prototype Approval:	N/A
Date: 10-11-8	Date: 10/11/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	
B	07.09.06	13.9° dimension added	KJ/JLM	
C	08.04.15	0.125 dimension removed	KJ/DD	

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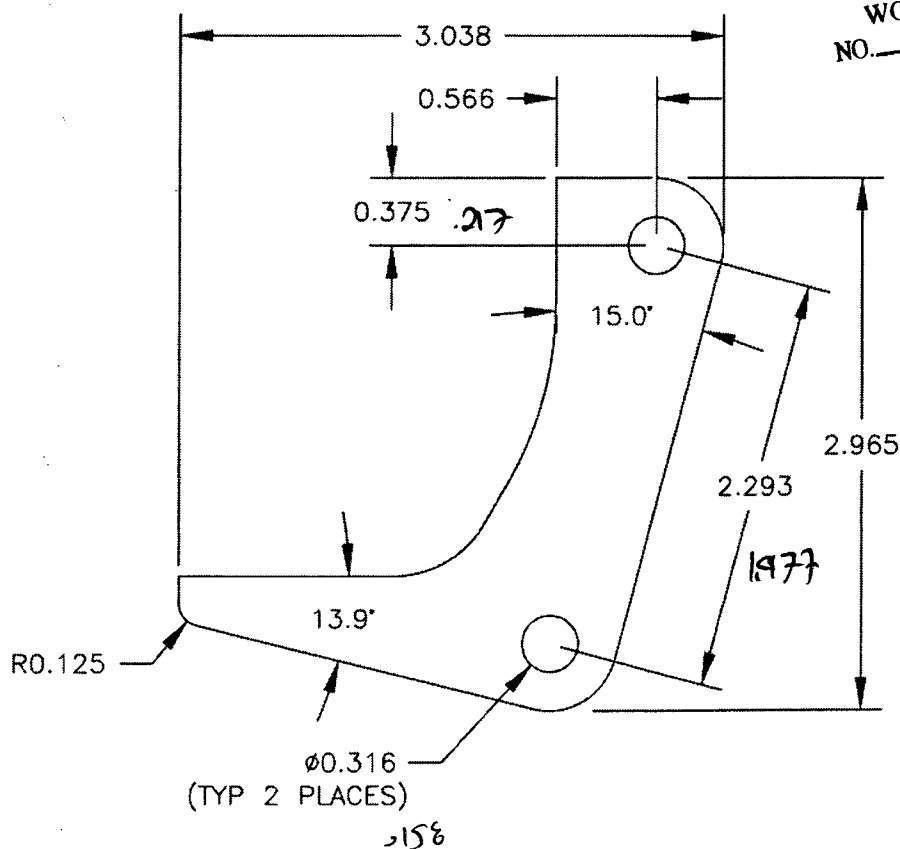
NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3219	REV. A SHEET 1 OF 1
DATE 03.10.10		TITLE PLATE	SCALE 1:1
A	03.10.10	NEW ISSUE	

RELEASED
04.04.05 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43551

**D3219-1 PLATE**

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRF"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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